

Date: Thursday, 15/05/2008 8:09:56 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 39276
 Estimate Number : 13309
 P.O. Number :
 This Issue : 15/05/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL / MED FAB
 Previous Run : 39252
 Written By :
 Checked & Approved By :
 Comment : Est Rev. 08-05-13 new issue DD verified by:

Drawing Name : WEARPLATE
 Part Number : D37911
 Drawing Number : PRELIM
 Project Number : N/A
 Drawing Revision : PRELIM
 Material :
 Due Date : 22/05/2008 Qty: 40 Um: Each

10

POSITIVE
RECALL

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.3063 sf(s)/Unit Total : 12.2514 sf(s)

M304S16GA Stainless steel sheet 0.063" thick

Batch: 108690

IB 8-5-21

MAT NOT BULLEN

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3791

Dwg Rev: PRE

Prog Rev: PRE

IB 8-5-21

40

2-Deburr if necessary

IB 8-5-21

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

0805-21

40

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Deburr if necessary

2-Form on Brake as per Dwg D3791 using Jigs

IB 08/05/21

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Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

08/05/22 (+40) counter

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: 1-Weld hardcoat as per dwg D3791 QSI004

Hardcoat 2059b Batch: M105959.

08-05-22 SP

(10X)

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

Pd 08-05-22

(10X)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Pd 08.05.23

08/05/22 (+10)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M105642

(10X)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:20
320°F
11:50

M-P 08/05/22

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Pd 08-05-22 @.

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

F-P 20

M-P 08/05/22

(10X)

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Drawing Name: WEARPLATE

Job Number: 39276

Part Number: D37911

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/23 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-22

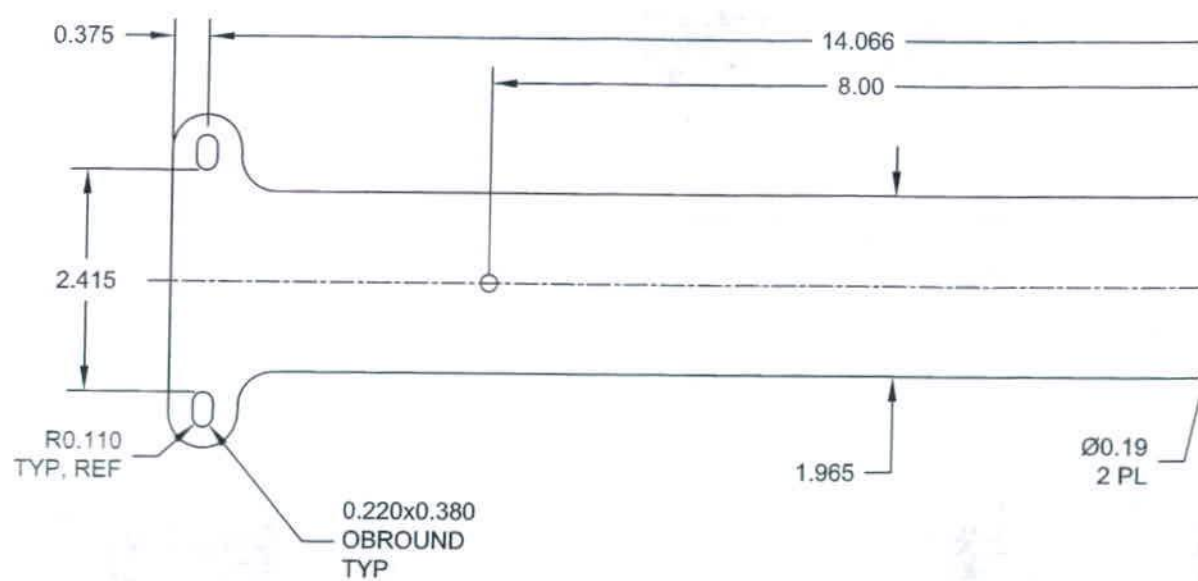
POSITIVE RECALL

RECEIVED 08-15-15 AUTH *[Signature]*

RELEASED *[Signature]* DATE 08-05-23

8 7 6 5

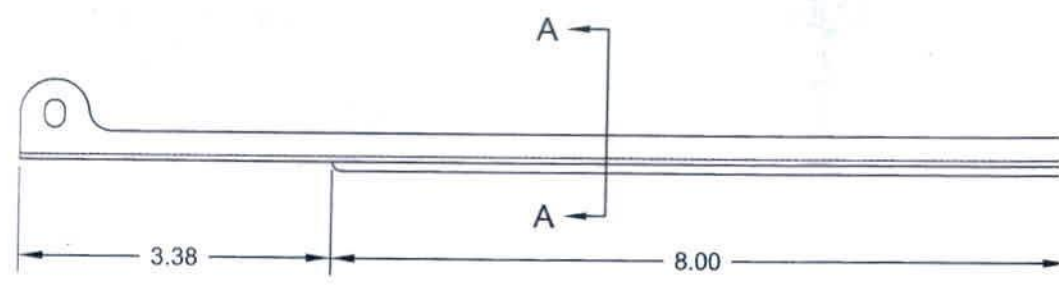
D



C

D3791-1F FLAT PATTERN

B



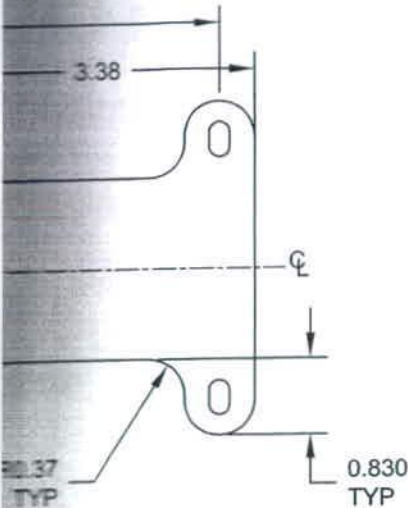
D3791-1 WEARPLATE
(MAKE FROM D3791-1F)

NOTES:

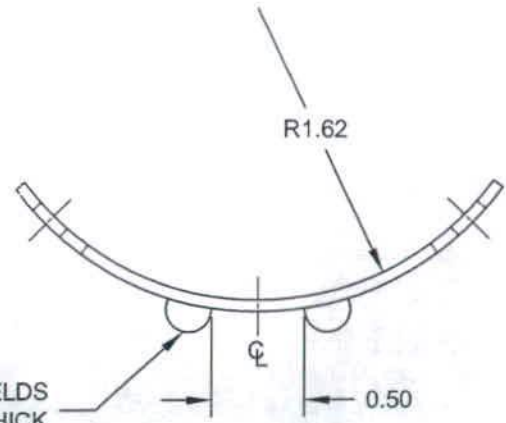
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.70 LBS
- 8) WELD PER DART QSI 004

A

8 7 6 5



2059B HARDCOAT WELDS
0.063 TO 0.125 THICK

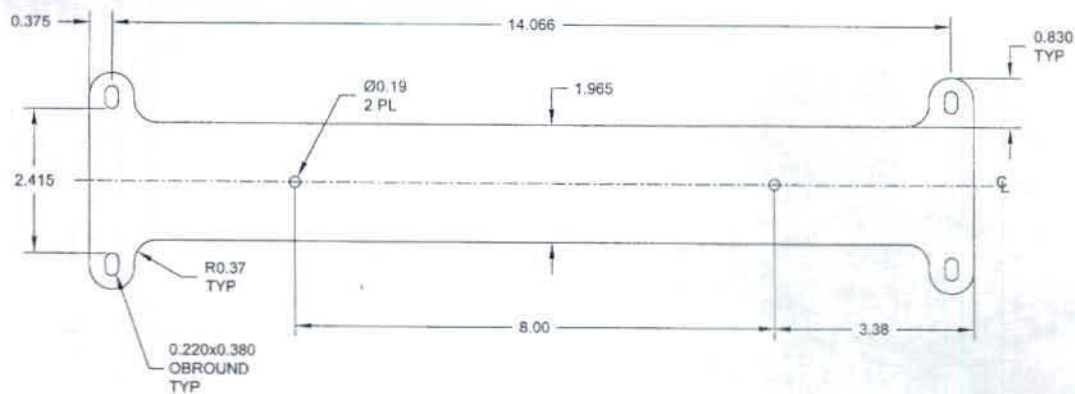


SECTION A-A
SCALE 2X

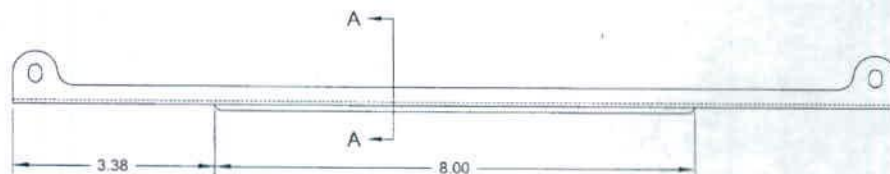
PRELIMINARY ISSUE
PH 03.05.15

WLO
29276

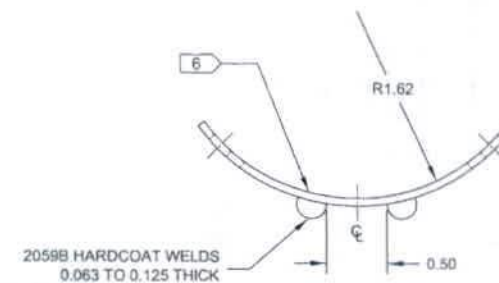
| | | | |
|------------|---------------|---|--------------|
| A | NEW ISSUE | PH | 08.05.13 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | PH | DART AEROSPACE USA, INC PORT HADLOCK, WA | |
| DRAWN | PH | | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | PH | D3791 | SHEET 1 OF 1 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | WEARPLATE | NTS |
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D3791-1F FLAT PATTERN



D3791-1 WEARPLATE
(MAKE FROM D3791-1F)



SECTION A-A
SCALE 2X

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3791-1" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.70 LBS
- 8) WELD PER DART QSI 004

W/O #39276

RELEASED
08-05-13

| A NEW ISSUE | | PH | 08.05.13 |
|-------------|-------------|---|--------------|
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | <i>PH</i> | DART AEROSPACE USA, INC PORT HADLOCK, WA | |
| DRAWN | <i>PH</i> | | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | <i>PH</i> | D3791 | SHEET 1 OF 1 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | <i>PH</i> | WEARPLATE | NTS |
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